

Work Order ID 70845

Thursday, June 16, 2011 11:22:20 AM

Page 1

Item ID: D4154-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate Assembly

Start Date: 6/16/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4154

B

0.00

100



Large Fab

0.00

Large Fab

Memo

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH#: M117659

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: M117659

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

0.00

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

11-6-20 (X1)

M117659

Work Order ID 70845

Page 2

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Item ID: D4154-041

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Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

150



Small Fab

Small Fab

Memo

0.00

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

16 06-22

Work Order ID 70845

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Page 3

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Handwritten: JWS HAI ONLY Not sellable!

Handwritten: 6/16/2011

Picklist Print

Thursday, June 16, 2011 11:22:17 AM

Page 1

Work Order ID: 70845



Parent Item: D4154-041



Parent Item Name: Wearplate Assembly

Start Date: 6/16/2011

Required Date: 6/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
10.11.04 added DT9684 DD verf:EC
per dwg revB DD verf:EC

IPP Rev:B
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4154-1		Manufactured	No			100	Each	2.0000	1	1			
										EL		16-6-20	
Plate													

Location

Loc Qty

Loc Code

WA

2

66312

1

69683

1

D4155-1		Manufactured	No			100	Each	7.0000	1	1			
										EL		11-6-20	
Bar													

Location

Loc Qty

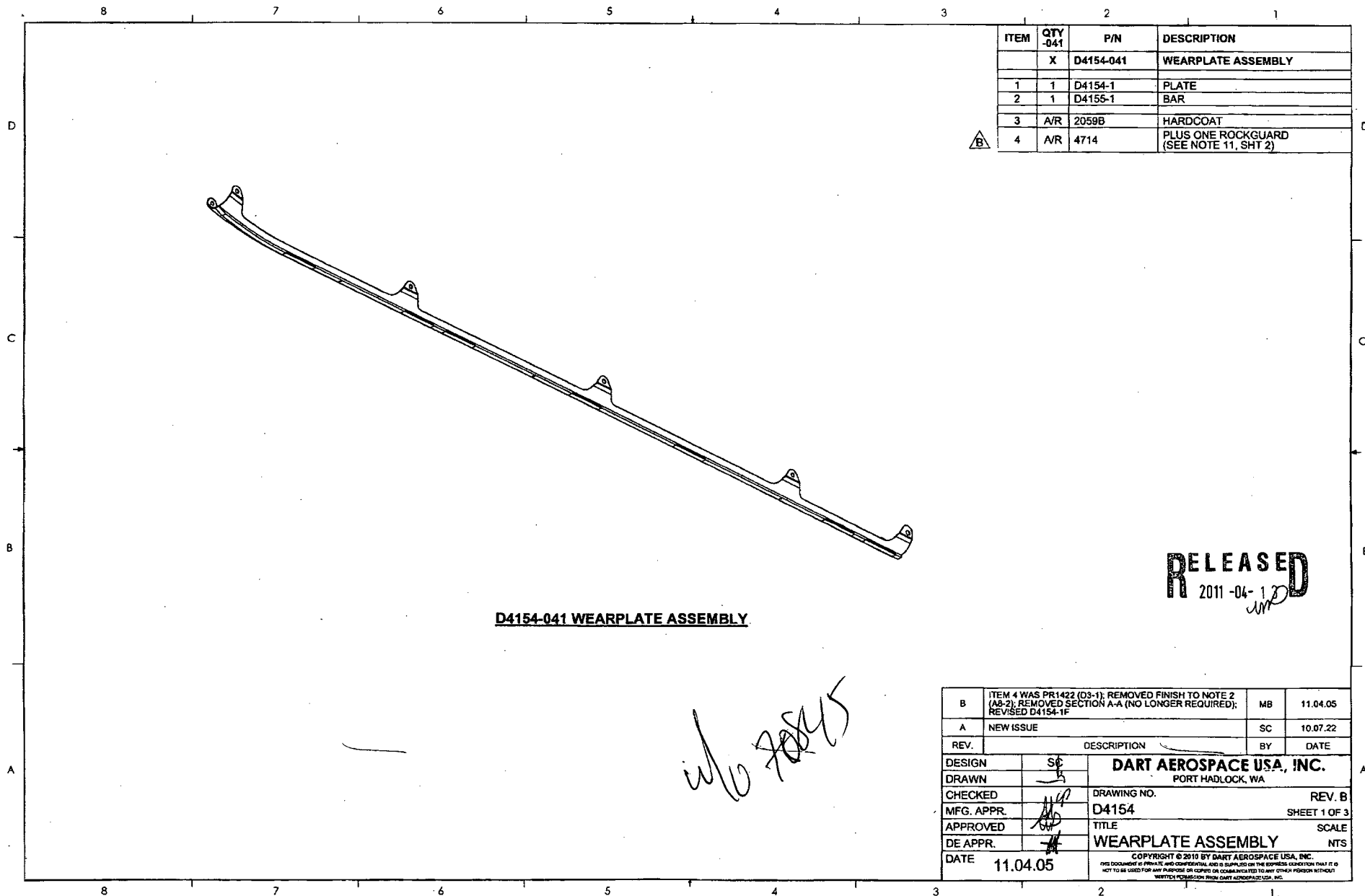
Loc Code

WA

7

69810

7



D4154-041 WEARPLATE ASSEMBLY

info 70845

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)

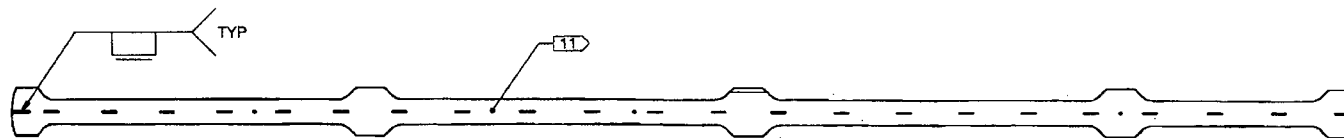
△/B

RELEASED
2011-04-13

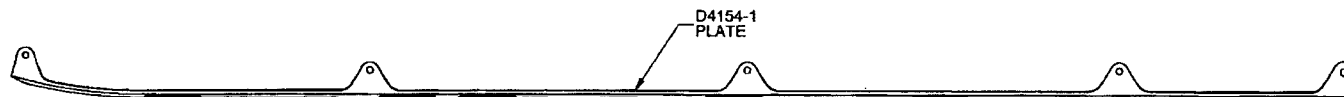
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	SC	DRAWING NO.	REV. B	
CHECKED	MP	D4154	SHEET 1 OF 3	
MFG. APPR.	MP	TITLE	SCALE	
APPROVED	MP	WEARPLATE ASSEMBLY	NTS	
DE APPR.	MP	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		
DATE	11.04.05			

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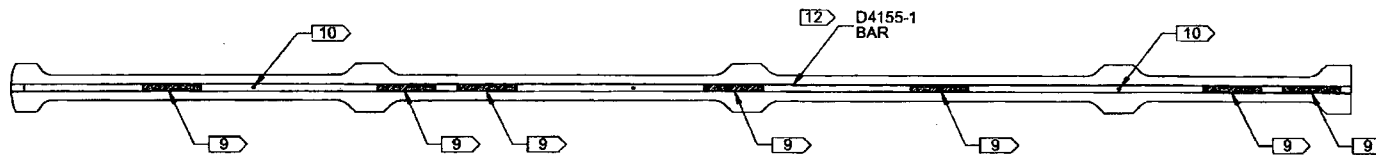
D



C



B



D4154-041 WEARPLATE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL \varnothing 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

B

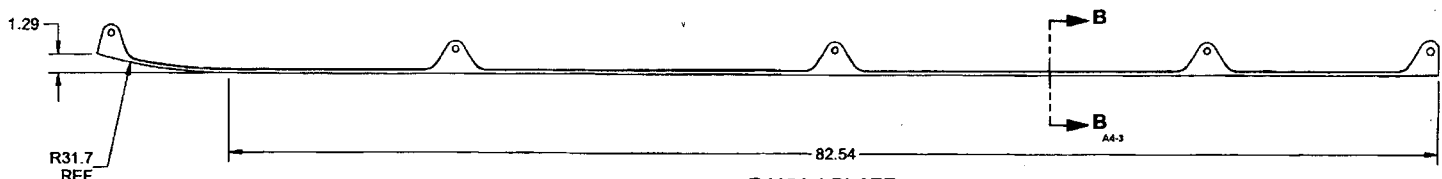
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2011-04-13

70845

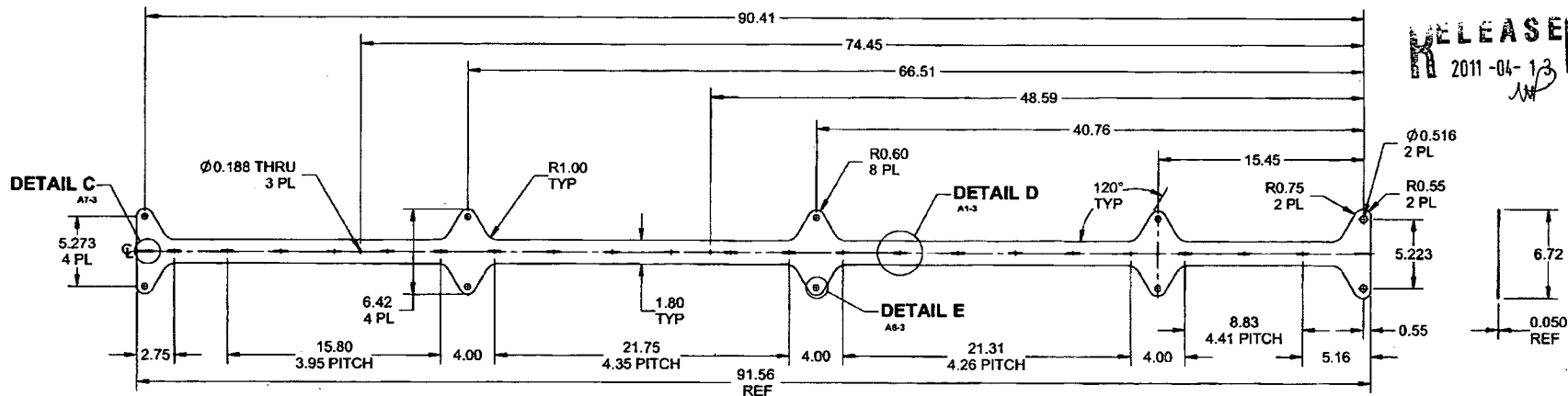
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	CP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4154	SHEET 2 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSEMBLY	NTS
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

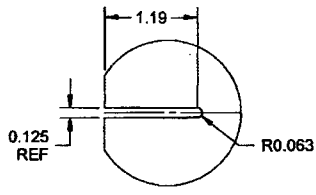


D4154-1 PLATE
(MAKE FROM D4154-1F)

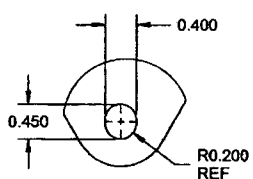


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2011-04-13

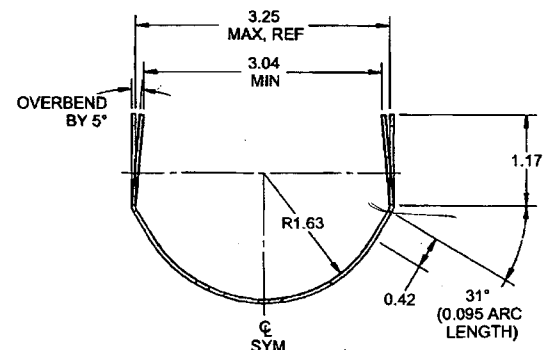
D4154-1F FLAT PATTERN



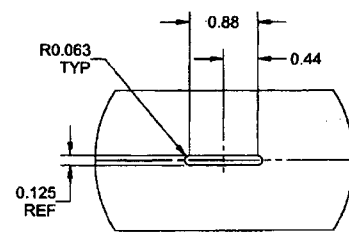
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4154	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSEMBLY	NTS
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